

Date: Saturday, 19/04/2008 10:40:56 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SLIDER
Job Number : 38695	
Estimate Number : 13245	
P.O. Number :	Part Number : D36951
This Issue : 19/04/2008 S.O. No. :	Drawing Number : D3695 REVA PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A PRELIM 08.05.18
Previous Run : 38476	Material :
Written By : <i>[Signature]</i>	Due Date : 26/04/2008 Qty: 2 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A 08-03-27 new issue DD verified by: JLM	

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.8400 f(s)/Unit Total: 1.6800 f(s)  
 6061-T6 Bar 2.0" x 1.25" 2.5 x 3.5  
 BATCH: *410045T* m18398

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: Cut blank 9.450" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA739 Rev. *A* & Dwg D3695 Rev. *A*

2-Deburr per dwg D3695 \

3-Manually Tap for 10-32 heli coil

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.1 Machine per updated hand changed dwg:

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDER

Job Number: 38695

Part Number: D36951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/05/06 (2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FF 08-05-14 (2)

8.0

MS21209F120

HELI COIL



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

HELI COIL

Batch: M 107823

FF 08-05-14 (2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install 10-32 Helicoil as per Dwg D3695

FF 08-05-14 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



08-05-14 (2)

Comment: INSPECT WORK TO CURRENT STEP

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: \_\_\_\_\_

N/A

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.04 Promonje

Job Completion



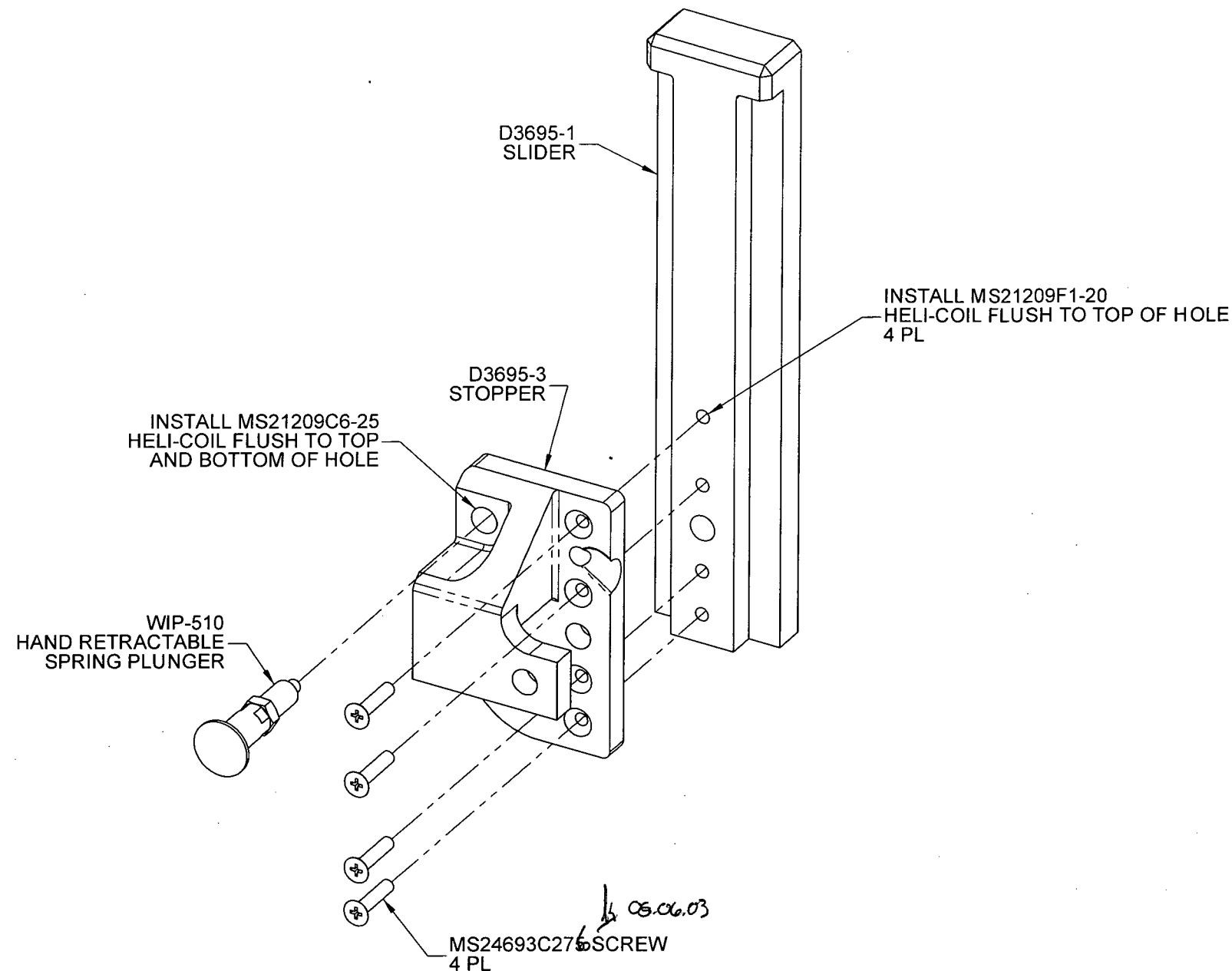
POSITIVE RECALL

EFFECTIVE DATE

RELEASED DATE

Charge To 00224A

PLC (2)



### D3695-041 SLIDER ASSEMBLY

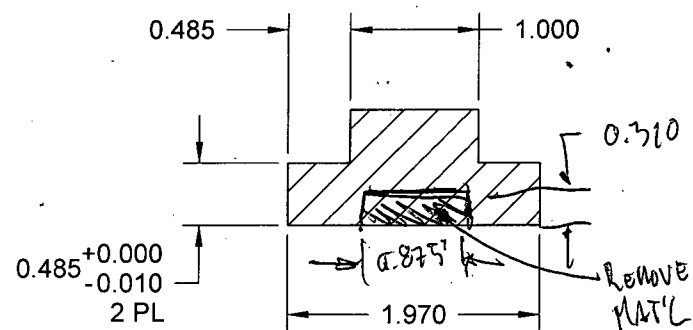
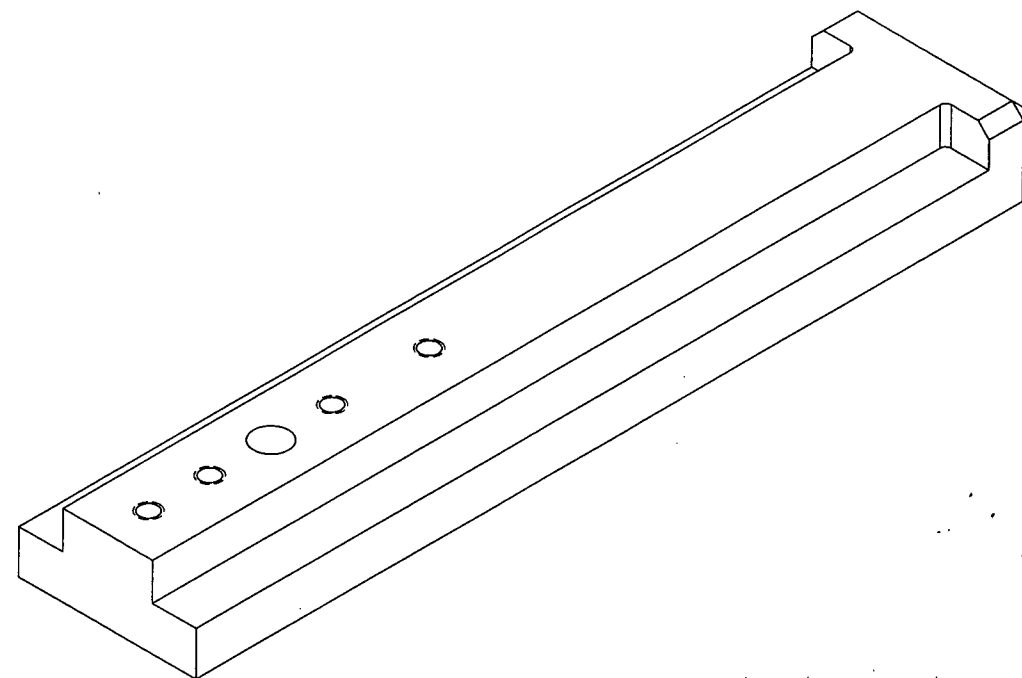
#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3695-041 = 0.75 lbs  
D3695-1 = 0.40 lbs  
D3695-3 = 0.20 lbs

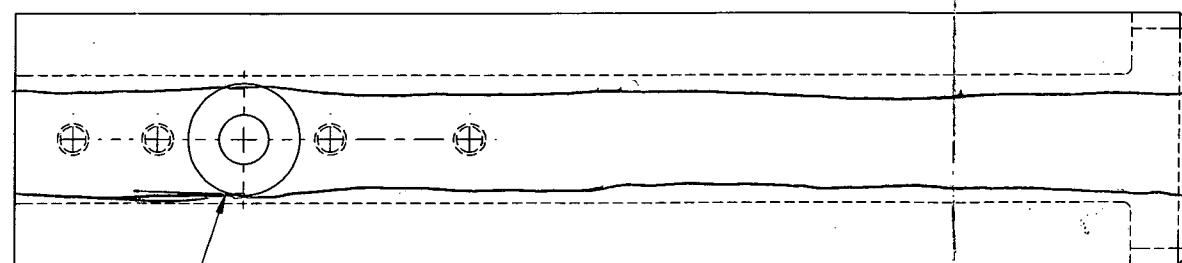
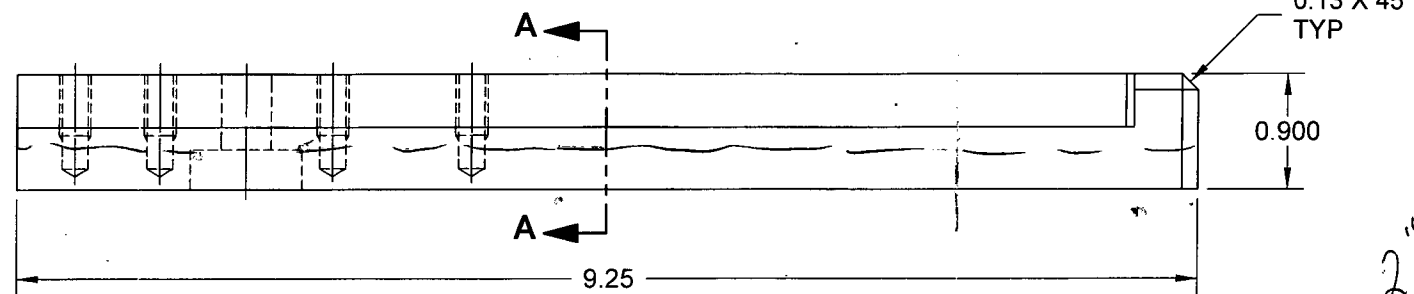
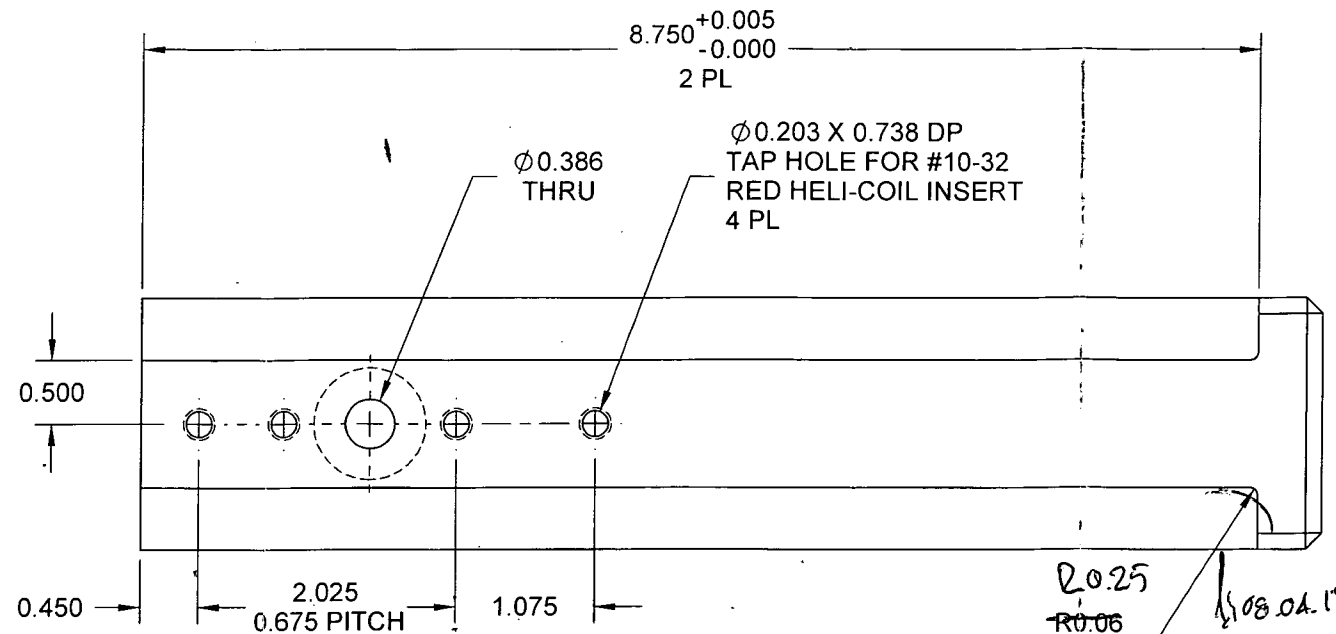
QTY -041	P/N	DESCRIPTION
X	D3695-041	SLIDER ASSEMBLY
1	D3695-1	SLIDER
1	D3695-3	STOPPER
1	MS21209C6-25	HELI-COIL, SCREW LOCKING (RED)
4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
1	WIP-510	HAND RETRACTABLE SPRING PLUNGER
4	MS24693-S275	SCREW

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
**PRELIMINARY ISSUE**  
08.06.17

A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3695	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	1:2
DATE	08.03.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**SECTION A-A**



CBORE Ø0.875  
X 0.310 DP

**D3695-1 SLIDER**

2" X 1.25" X 9.450

10739

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

**PRELIMINARY ISSUE**

08.04.17

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3695</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SLIDER ASSEMBLY</b>	NTS
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	38695
<b>Description:</b> slider		<b>Part Number:</b>	D 3685
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.970	±.010	1.971	/			
.485	±.008 ±.010	.482	/			
.485	±.010	.486	/			
1.000	±.010	.999	/			
8.750	±.003 ±.000	8.750	/			
Ø.386	±.006 ±.001	Ø.388	/			
.500	±.005	.500	/			
.450	±.005	.448	/			
2.025	±.010	2.022	/			
1.075	±.010	1.074	/			
R.25		R.25	/			
Ø.203 X	±.006 ±.001	Ø.206	/			
.738 NP	±.010	.730	/			
9.25	±.030	9.279	/			
.900	±.010	.898	/			
138.45°	±.030	130x45°	/			
C-bore Ø.875	±.010	Ø.880	/			
X .310 NP	±.010	.312	/			

<b>Measured by:</b> SD	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> [Signature]
<b>Date:</b> 08/05/04	<b>Date:</b> 06-05-13	<b>Date:</b> 06.06.04

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Date: Saturday, 19/04/2008 10:40:56 AM  
User: Jean-Luc Menard

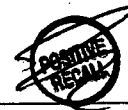
# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDER
Job Number	: 38695	Part Number	: D36951
Estimate Number	: 13245	Drawing Number	: D3695 REVA PRELIM
P.O. Number	:	Project Number	: N/A
This Issue	: 19/04/2008 S.O. No. :	Drawing Revision	: A PRELIM
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : MACHINED PARTS	Due Date	: 26/04/2008 Qty: 2 Um: Each
Previous Run	: 38476		
Written By	: <i>[Signature]</i>		
Checked & Approved By	:		
Comment	: Est Rev: A 08-03-27 new issue DD verified by: JLM		

Additional Product

FOR ENGINEERING USE ONLY

**PROTOTYPE**



Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B2000X01250

6061-T6 Bar 2.0" x 1.25"



*Copper + Brass*



Comment: Qty.: 0.8400 f(s)/Unit Total : 1.6800 f(s)

6061-T6 Bar 2.0" x 1.25"

BATCH: *1100451*

*P10: 808*  
*2008*

2.0

BAND SAW

BAND SAW



Comment: Cut blank 9.450" long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA739 Rev. *A* & Dwg D3695 Rev. *A*

2-Deburr per dwg D3695 \

3-Manually Tap for 10-32 heli coil

*SA 08/05/04*

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SA 08/05/04*

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Supplier: Copper Brass

Dart P/O: 808

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒  
 Shipment Complete: Yes ☒ No ☐  
 Q.C. Inspection ☒

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>NEW 108</u>	<u>M6061T6T0625W065</u>		<u>50 R 100</u>			

TSR No. \_\_\_\_\_

Initials of receiver (if shipment OK) [Signature]

Production/Admin: \_\_\_\_\_

Accounting: \_\_\_\_\_

Date 06/03/22

Date \_\_\_\_\_

Received/Costing FCR 108

AP/MR \_\_\_\_\_

Initial AK

Initial \_\_\_\_\_

H:\ISO9000\Forms\Purchase\RECREPORT rev B

"Shipping, do not place any packages or goods on top of our material."									
FULL	SCRAP	FILLED BY	SC	PACKED BY	QA AUDIT				
CUSTOMER RECEIVING HOURS	MAX SKID WEIGHT	LOADING INSTRUCTIONS	MAXIMUM BUNDLE WEIGHT						
8-3	100	HAND, CRANE, FORK, DOCK	200						
BOXES	BARS	CASES	CUSHP	PKGS	SKIDS				
INSPECTION RECORD									

TEST RESULTS

CERTIFICATE OF COMPLIANCE  
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.  
 The products we distribute are not hazardous in their received state. For MSDS sheets go to [www.copperandbrass.com/msds](http://www.copperandbrass.com/msds)  
 or call 248-233-5682. We hereby certify that the material above complies with the following specifications:

ASTM-B210      AMS 4082      WW-T-700/6F  
 ROHS CERTIFIED

TAG NO	QUANTITY	UOM	VENDOR	VEND PO	HEAT/LOT	PCS	TAG NO	QUANTITY	UOM	VENDOR	VEND PO	HEAT/LOT	PCS
	1.00	PC	KAISER	OCG4901	44088 B	1		8.00	PC	KAISER	0CH4655	44538	

MARY L. TAYLOR

- General Manager: TORONTO

PRINTED 03/20/06 12:07 PM

CONTROL NO 00057

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4111 S 74 E Ave  
TULSA, OK 74145

KAISER ALUMINUM  
NATURAL CERTIFICATION  
COPPER & BRASS SALES  
CUSTOMER PICK-UP  
1310 SCHLIMMER N.W.  
GRAND RAPIDS, MI 49504

PAGE 1

COPPER & BRASS SALES  
SOUTHERN MI 48828 C74842  
SOLD TO PURCHASE ORDER  
DATE PRINTED: 03/04/06

SOLD TO PURCHASE ORDER  
DATE PRINTED:

020354-7  
CUSTOMER PART NUMBER  
DESCRIPTION  
2.250 X 8.000 RECT BAR  
6061-T5511  
ALLOY/Temper

803727-001  
RELEASE-ITEM  
GRS 177  
LOT

MECHANICAL PROPERTY RESULTS

REFERENCE SAMPLE# UTS(KSI) YTS(KSI) %ELONG 1/8" 3" HARDNESS CORRECT. HARD  
606 177 0001 0001 50.3 50.9 12.0 N/A N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REFINED

	SI	FE	CU	MN	MG	CO	ZN	TI	BP	SI	AS	SE	OTHER
6061 LIMITS	0.60	0.70	0.40	0.15	1.30	0.35	0.25	0.15	NA	NA	NA	NA	0.05 0.15
Maximum	0.40	0.00	0.18	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	NA	0.00 0.00
Minimum													

SOLD TO \_\_\_\_\_

DATE \_\_\_\_\_

CUSTOMER P.O. \_\_\_\_\_

CUSTOMER P/N \_\_\_\_\_

SHIPPER NO. \_\_\_\_\_

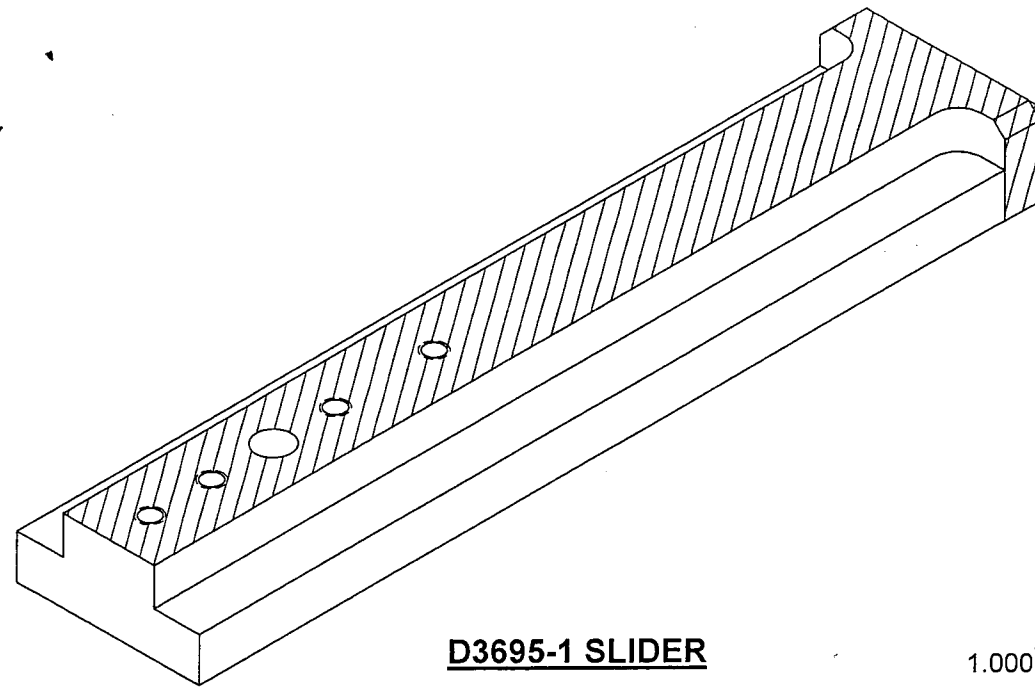
QUANTITY \_\_\_\_\_

BY  
COPPER and BRASS SALES INC.

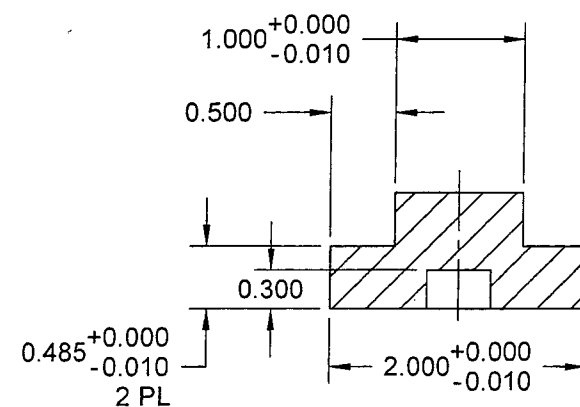
APPLICABLE REQUIREMENTS:

ASTM-B221-02-STANDARD  
ASME-B221-1998 SECT II  
NBS-QC-A-300/B  
UNSP98061

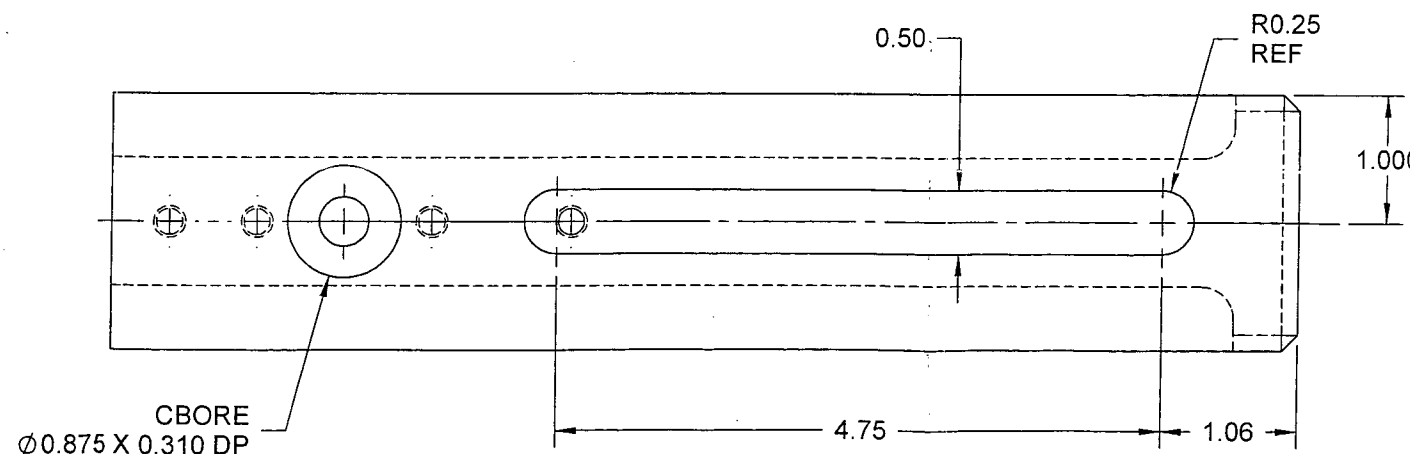
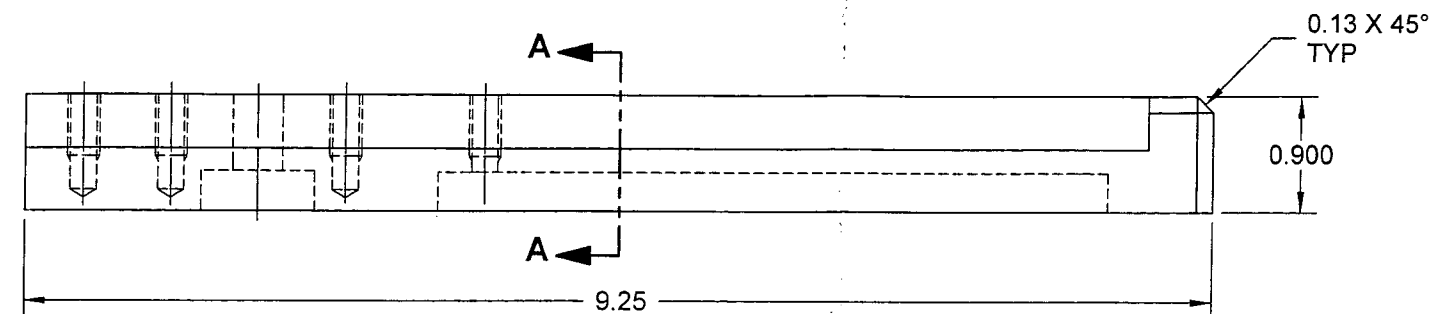
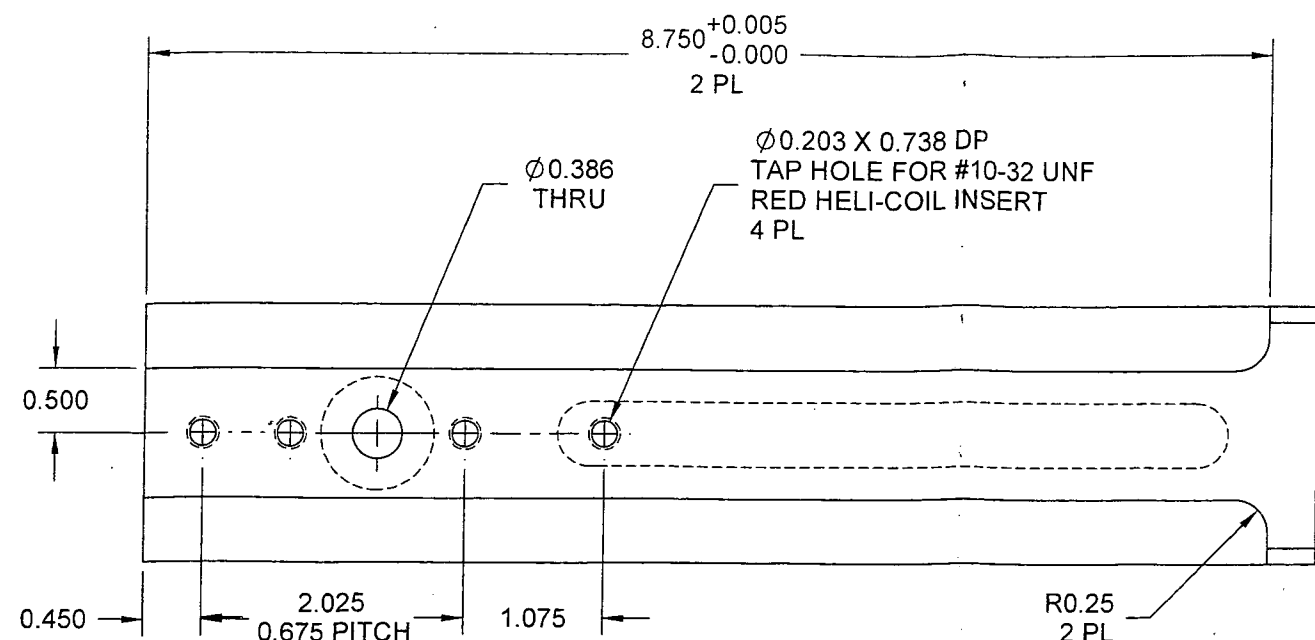
Kaiser Aluminum & Chemical Corp. ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the specification set forth in Kaiser's sales order/edge-mount form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.



**D3695-1 SLIDER**



**SECTION A-A**



**D3695-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART  
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

**PRELIMINARY ISSUE**  
18.08.09.05

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
DATE	08.06.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	